

6/1/2018

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400234

Job Sheet 176407



Part No: RBT400234

Job Qty: 1 ea

Part Name: Callibrator Assembly



Part Weight: 0 lbs

Job Created: 4/23/18

Due Date: 6/5/18

Type: SOLD

Status: At Planning

Priority: Medium

Job Tracking No:

Created By: Logan David

Description:

Note: DWG RBT400234 Rev. 0 IPP Rev. A 18.04.20 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		6/5/18	0.00	0.00	Start Up Large Fab-7		18-05-04
110	Large Fab	1 pcs		6/5/18	0.00	1.00	Large Fab 3		18-05-04
120	QC	1 pcs		6/5/18	0.00	0.00	QC9		12
125	Mill Conv	1 pcs		6/5/18	0.00	0.10	Mill Conv 2		18/6/15
126	QC	1 pcs		6/5/18	0.00	0.00	QC2 Machining-4		18/06/15
127	QC	1 pcs		6/5/18	0.00	0.00	QC8 Machining-4		18/06/15
130	Outsource	1 pcs		6/5/18	0.00	0.00	Outsource3		18-06-15
150	Packaging	1 pcs		6/5/18	0.00	0.00	Packaging2		38
160	QC	1 pcs		6/5/18	0.00	0.00	QC6		9-30
170	Packaging	1 pcs		6/5/18	0.00	0.00	Packaging3		18-06-15
180	QC21-FG	1 Ea		6/5/18	0.00	0.00	QC21		18-06-15

Part Op 110 - Weld as per DWG. Sheet 2.

Descriptions: 125 - Machine 0.482" dimension sheet 4.

130 - Issue P/O to GROUPE ALTECH: P/O 0410126 - Cadmium plating, QQ-P-416F TYPE II, CLASS II - Color;

Yellow - Certificate of Conformity is required

170 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400234-3	Plate	1 Ea (1 ea)	100-Start up Operation	5065677
RBT400234-5	Bar	1 Ea (1 ea)	100-Start up Operation	5065662
RBT400234-7	Block	1 Ea (1 ea)	100-Start up Operation	5066048

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	RBT400234-3	1	6 GA135	0
	RBT400234-5	1	6 "	0
	RBT400234-7	1	6 GA136	0



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S077633



Part: RBT400234

Job No: 176407

Serial No/Batch: S077633

Revision: 0

Inspector:

Exp Date: 06/04/2018

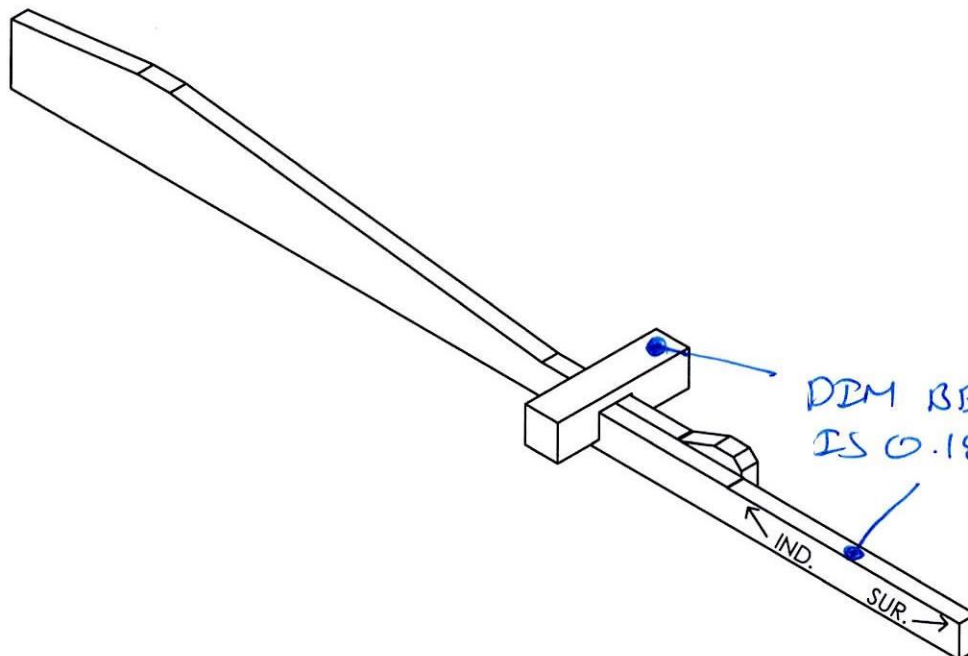
Instructions:

Date: 06/04/18

x 6/1/18 10:52 AM dart.logan.david

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176407
20180601

*DIM BETWEEN CRITICAL SURFACES
IS 0.182"*
ML 18/06/07

- NOTE:
1. REF. BELL T/N 206-215-002-105.
2. USED ON MODELS: 206A/B, 206B3, 206L, 206L1, 206L3, 206L4.

DART AEROSPACE	
TITLE CALIBRATOR ASSYMBLY	
DWG NO. RBT400234	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206 ALL SEE NOTE 2
SCALE 1:2	DATE 6/30/2014 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	WELDMENT			2
	1		-3		PLATE	1018	1/4 X 1-1/4 X 11-5/16	3
	1		-5		BAR	1018	1/4 X 1/2 X 6-1/4	4
	1		-7		BLOCK	1018	1/2 X 5/8 X 2-1/8	5
	ASSY -1							

176407

Page 1 of 1

See M-Lee for final dim.



Engineering Approval:
(If necessary)

Rev
A

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>176407</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>BST 400 234</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No.		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval <i>Mka</i>
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Description Work Order Deviation	Disposition	Completed By
DIM BETWEEN CRITICAL SURFACES INDICATED ON ATTACHED DRAWINGS IS 0.182"	THIS DEVIATION IS ACCEPTABLE. TOOK WELL SURVEY AS INTENDED.	<i>JUNE 5/18</i>
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>176407</u> Part No. <u>RBT 400 234</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>18/06/07</u>		Step #: <u>125</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval																																																																		
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040126**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040126
PO Date: 6/7/18
Due Date: 6/8/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176407	RBT400234	Calibrator Assembly -Issue P/O to GROUPE ALTECH: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	6/8/18	5 pcs	0 pcs 5x	5 pcs	\$59.00/pcs	\$295.00 18/06/15

Grand Total: \$295.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/8/18 7:51 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010098- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
13-Jun-2018		Ross Montieth		040126				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT400234 Rev.	RBT400234 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] TYPE 2 CLASS 2 0.0003 THICK BAKE	CADMIUM CH	5	5	0	0	0
2	RBT400234 BAKE Rev.	RBT400234 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	CADMIUM MIN-CHG	1	1	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.